

Work Order ID 160945

Friday, May 05, 2017 10:21:13 AM

160945

Page 1

Item ID: PB67-43001-205W

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Outer Tube Weldment

Start Date: 5/10/2017 Start Qty: 7.00

7

Cust Item ID:

Required Date: 5/18/2017 Req'd Qty: 7.00

7

Customer:

Reference: SCHEDULED/U

Approvals: Process Plan: DAS 21 Date: MAY 05 2017 Tooling: _____ Date: _____
QC: 9-89 Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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B67-43001-07	<u>DE</u>
--------------	-----------

100

BAND SAW

0.00

100

Bandsaw

Jeaspa Bandsaw

Memo

- 1- Cut to length as per dwg
- 2- Cut a angle on one end of tube as per dwg
- 3- Deburr

0.90

meter:

P/O: 36325

7

MAY 09 2017

DAS
13
9-89

110

CONVENTIONAL MILLING MACHINE

0.00

110

Mill Conv

Conventional Milling Machine

Memo

- 1- drill holes and mill slot as per dwg PB67-43001 USE DT8792
- 2- deburr

4.40

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Quality Control

Memo

0.00

7

DAS
38
9-89
MAY 24 2017

Rec'd + inspect
attached c/c to w/o.

SP17-523

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____	
Description Work Order Deviation				Disposition					

Root Cause			FAULT CATEGORY							
Environment ☐	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong
Design ☐	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions
Doc/Data ☐	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance
Equip/Tooling ☐	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect
Handling/Pre ☐	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing
Material ☐	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved
Internal Transport ☐	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing
Tribal Knowledge ☐	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish
LOA ☐	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread
Substation ☐	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence
Past Expiry Date ☐	☐	Manufacturing Process	OTHER : _____							
Misidentified ☐	☐	Past Due								

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Page 2

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Reference: SCHEDULED/U

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Large Fab	Weld per dwg A/R Aluminum rod Batch: <u>4129399</u> Large Fab	0.00				<u>7</u>	<u>62</u>	<u>17-5-25</u>	
Large Fab	Memo	0.00							
	1-Weld end cap as per dwg PB67-43001 2-Grind end cap flush								
140 *140* QC Quality Control	QC10- Inspect visual per QSI004- ground welds	0.00				<u>①</u>	<u>17-05-26</u>		DAS 9 9-89
	Memo	0.00							
150 *150* QC Quality Control	QC5- Inspect part completeness to step on W/O	0.00				<u>①</u>	<u>17-05-26</u>		DAS 9 9-89
	Memo	0.00							

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Work Order ID 160945

Friday, May 05, 2017 10:21:13 AM

160945

Page 3

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: W4003	0.00							
160									
Packaging	Memo	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

MAY 26 2017

DAS
6
-89

17/5/31 JH

MAY 30 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																											
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval																																																							
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																							
Root Cause		FAULT CATEGORY																																																													
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER :	
Misidentified ☐	Past Due ☐																																																														

Picklist Print

Friday, May 05, 2017 10:21:12 AM

Page 1

Work Order ID: 160945

160945

Parent Item: PB67-43001-205W

PR67-43001-205W

Parent Item Name: Outer Tube Weldment

Start Date: 5/10/2017

Required Date: 5/18/2017

Start Qty: 7.00

Required Qty: 7.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6T1.750W.065

Purchased

No

100

f

50.3690

3.615

26.63684

MAY 31 2017

13
8:30

M6061T6T1 750W 065

6061T6 RDTUBE 1.750 X 0.65W

Location

Loc Qty

Loc Code

MAT016

50.369

M133700

7.681

M136283

42.688

PB67-43001-199

Manufactured

No

130

Each

4.0000

1

7

PR67-43001-199

Outer Tube End Cap

Q 175-25

Location

Loc Qty

Loc Code

Mezz2

4

142940

4

160958 x 3

4

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐								
		OTHER : _____							

DART AEROSPACE LTD		Work Order:	160945
Description: Outer Tube		Part Number:	B67-43001-205
Inspection Dwg: B67-43001-205 Rev: DE		Page 1 of 1	

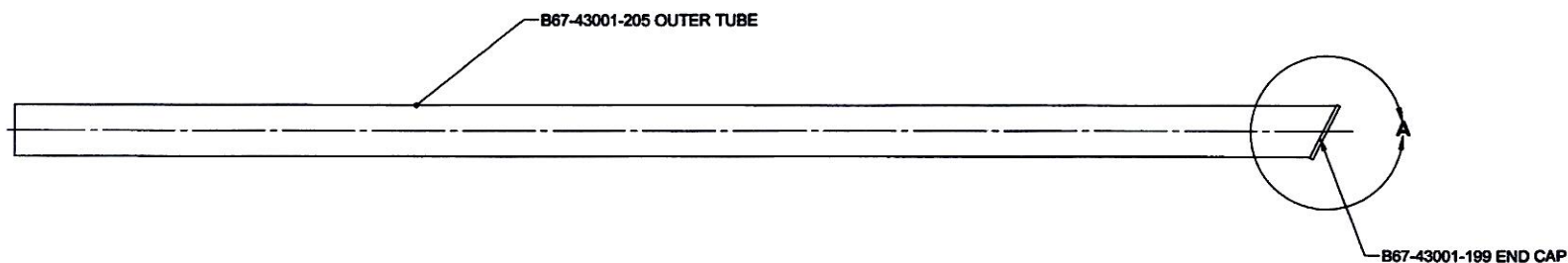
[illegible]

Measured by:	38 9-89	Checked by:		QC Inspector:	
Date:	MAY 24 2017	Date:		Date:	

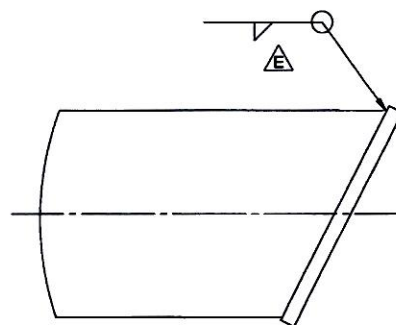
Engineering Approval: (If necessary)		Date:	
--	--	--------------	--

Rev	Date	Change	Revised by	Approved
A	09.05.20	New Issue	KJ	
B	16.10.20	Dwg Rev updated	KJ	

ITEM	QTY -205W	P/N	DESCRIPTION
	X	B67-43001-205W	OUTER TUBE WELDMENT
1	1	B67-43001-199	END CAP
2	1	B67-43001-205	OUTER TUBE



D67-43001-205W OUTER TUBE WELDMENT



DETAIL A
SCALE 4X

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 160945MUS
170505

E	UPDATED MATERIAL SPECIFICATION, CHANGE GRINDING NOTE ON END CAP WELD, REASON PAR15-437	SAD	16.10.17
D	CHANGE HOLE LOCATION (ZN CS-2), ADD -205W WELDMENT; REASON: FACILITATE MANUFACTURING	DB	14.07.15
C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 16 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR109-011.	MB	09.02.27
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE USA, INC. EUGENE, OR	
DRAWN	SAD		
CHECKED	MB	DRAWING NO.	REV. E
MFG. APPR.	DD	B67-43001-205	SHEET 1 OF 2
APPROVED	WM	TITLE	SCALE
DE APPR.	N/A	OUTER TUBE	NTS
DATE	16.10.17	COPYRIGHT © 1995 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

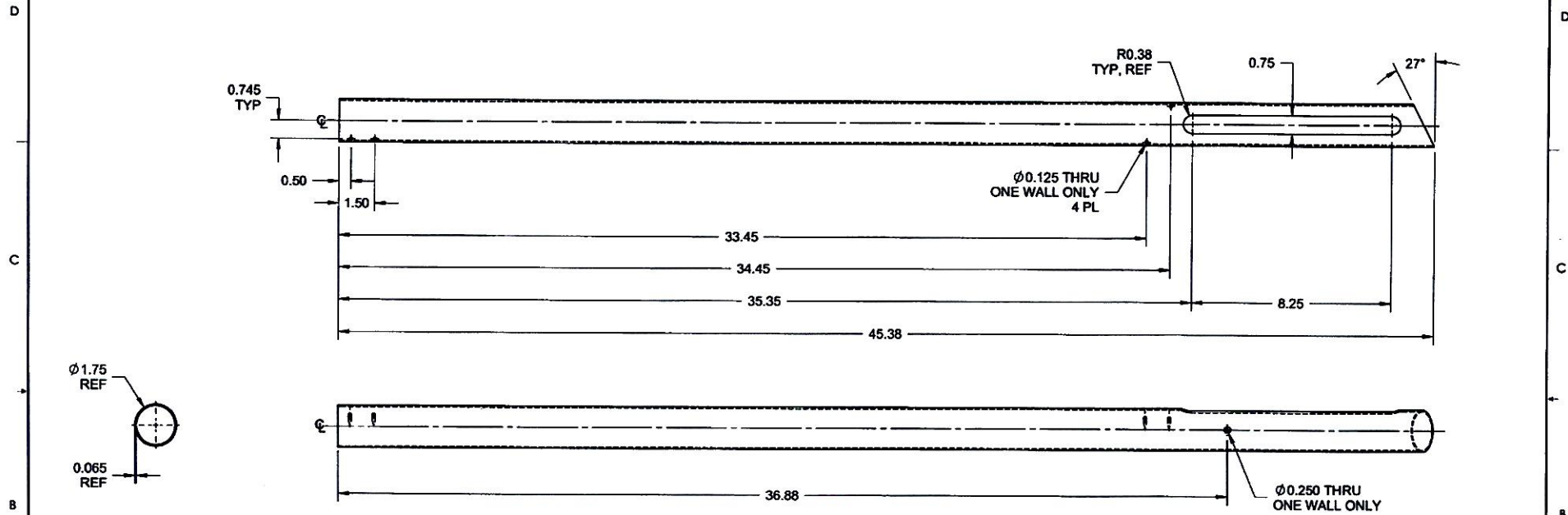
APPROVED

RELEASED
2016-11-09
EW 6-855 OM

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.50 lbs
- 8) WELDING: PER DART QSI 004

8 7 6 5 4 3 2 1



B67-43001-205 OUTER TUBE

NOTES:

- 1) MATERIAL: 6061-T6 OR 6061-T62/T6511 ALUMINUM SEAMLESS TUBING
PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR
AMS 4083 OR AMS-QQ-A-200/8 OR AMS-QQ-A-225/8
OR ASTM B210 OR ASTM B241
REF. DART SPEC. M6061T6T1.750W.06
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.46 lbs

RELEASED
2016-11-09

APPROVED
D

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SAD		
CHECKED	MB	DRAWING NO.	REV. E
MFG. APPR.	DD	B67-43001-205	SHEET 2 OF 2
APPROVED	WM	TITLE	SCALE
DE APPR.	N/A	OUTER TUBE	NTS
DATE	16.10.17	COPYRIGHT © 1986 BY DART AEROSPACE LTD THIS DOCUMENT IS PROPRIETARY AND IS SUPPLIED ON THE EXPRESSED CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO36235**

Purchase Order Date 5/8/2017

PO Print Date 5/18/2017

Page Number 2 of 3

Order From :

METEC METAL TECHNOLOGY INC.
20 TERRY FOX DRIVE PO BOX 781
VANKLEEK HILL, ON K0B 1R0
CA

VC-MET003

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone

613 678 3957

Ship To Contact

Ship To Phone

Ship Via:

Dart Truck

Ship Acct:

Buyer

Customer POID

Customer Tax #

Terms

Currency

FOB

Chantal Lavoie

10127-2607

Net 10

CAD

Destination-Collect

3

160839

PB67-43001-171
MONTING PLATE

5/23/2017

168.00

\$5.70

\$957.60

Yes

5/23/2017

FABRICATE AS PER DWG PB67-43001-171
SUPPLY MAT'L, 6061-T6 ANGLE 1" X .125" WALL M130524 AND D6207 B99224

Line Total:

\$957.60

4

160945

PB67-43001-205W
OUTER TUBE

5/23/2017

7.00

\$170.00

\$1,190.00

Yes

5/23/2017

ABRICATE AS PER DWG PB67-43001-205W
SUPPLY MAT'L, 6061-T6 ROUND TUBING 1.750" X .065" WALL M136283

Line Total:

\$1,190.00

DAS
38
9-88

SPH 5-23

Note:

5/18/2017



20 Terry Fox Drive
Vankleek Hill, Ontario K0B 1R0 , Canada
Tel: (613) 678-3957
Fax: (613) 678-3956

Delivery Slip No.: 21692
Date: May 18, 2017
Page: 1

Sold to:	Ship to:
Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No.: PO36235	Sold By: Walz, Christian D.
Shipped By:	Ship Date: May 18, 2017

Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
PB67-43001-87 Tube Arm	Each	3	3	
PB67-43001-113 square tube with cut-out 1 3/4" dia.	Each	3	3	
PB67-43001-171 Mounting Plate	Each	168	169	
PB67-43001-205W Outer Tube	Each	7	7	
2017-5-23				
The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.				
Received by _____		Thank you for your order!		

DAS
38
9-86



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0
Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

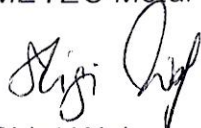
same

Quantity	Part Number	Part Name	Material & Batch #	P.O. Number
3	PB67-43001-87	Tube Arm	6061-T6 round tubing 1" x .065" wall M137286	36235
3	PB67-43001-113	Square Tube	6061-T6 square tubing 1" x .125" wall M128034	36235
169	PB67-43001-171	Mounting Plate	6061-T6 angle 1" x .125" wall M130524 and D6207 B99224	36235
7	PB67-43001-205W	Outer Tube	6061-T6 round tubing 1.750" x .065" wall M136283	36235

MATERIAL: supplied by DART

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.


Shigi Walz

Vankleek Hill, May 18, 2017